

Work Order ID 54515

December 10, 2009 2:35:26 PM



Page 1

Item ID: D105-674-011G

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube, Grey

Start Date: 10/12/2009 Start Qty: 1.00

Required Date: 23/12/2009 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *RL*Date: *09-12-10*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2966

Rev A2

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D105-674-011G CHG002

*81061/05**RL 09-12-10*

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Determine square end of tube and deburr
2-Drill #30 pilot holes using DT8678. Open holes to Ø5/16" (0.313"). Deburr holes.*> DP 9-12-14*

120

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend tube as per program BO105 on CNC Bender and Dwg D2966. Use 5/16" locator pin on buggy "A".

*> DP 9-12-15**PTO*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D105-674-011G PAR #: _____ Fault Category: Skirt tubes NCR: Yes No DQA: [Signature] Date: 10-01-07
 Resolution: Scrap Disposition: Scrap QA: N/C Closed Date: 10-01-07

NCR: <u>54515</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9-12-14	20	Tube crushed while bending process.	<u>CP</u> 09.12.14 <u>pu</u> 09.12.14	Scrap & Replace.	<u>[Signature]</u> 9-12-14	<u>[Signature]</u> 09.12.16	<u>CP</u> 09.12.16 <u>pu</u> 09.12.16	<u>[Signature]</u> 09.12.16

NOTE: Date & initial all entries

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130



Skidtubes

Skidtubes

0.00

0.00

Memo

- 1-Cut Fwd end of the tube using DT8185-1
- 2-Cut Aft end at 107.06" using DT8185D
- 3-Deburr ends
- 4-Drill Aft Cap holes using DT8678
- 5-Locate DT8679 with 1/8 clecos in Aft Cap holes. Ensure DT8679 is centered on Fwd end of tube and drill #40 Fwd bushing.
- 6-Clamp DT8679 to the tube. Drill all #30 wearplate and crossbolt holes.
- 7-Open Aft Cap holes using #6 drill
- 8-Open wearplate holes and two side holes to Ø19/64" (0.297") as per Dwg D2966-1.
- 9-Deburr holes.
- 10-Open remaining (16) crossbolt holes to Ø0.500

140



Skidtubes

Skidtubes

0.00

0.00

Memo

- 1-Weld Fwd Cap as per Dwg D2966 and QSI 004. Fill #40 Fwd cleco hole.
- 2-Grind Fwd Cap welds flush

Skidtubes

DP 9-12-16

BE 09-12-16
A/R M112860

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00	⇒ 8 or 12/16						
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	⇒ 8 or 12/16						(10) 16
170 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							1 4 9/12/16

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

190

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Open crossbolt holes to finish size as per Dwg D2966
2-Open 14 holes to Ø0.750" & 2 holes to Ø0.875", countersink crossbolt holes &
remove alodine to prepare for welding as per Dwg D2966
3-Deburr holes inside & outside, blow out chips

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

200

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Bond Web in place per QSI 015. (Ensure holes line up)

Pick:

QtyPart Numbe DescriptionBatch

A/RSikaflex-291 M112395

Sikaflex expiry date: 12/28

2-Weld Crossbolt Spacers as per Dwg D2966 and QSI 004. For crossbolt spacer, wel

11/9/12/16

11/9/12/16

3 grind Weld Flush

08/12/17

AR 112860

AWM 9-12-17

210

0.00



QC

Memo

0.00

Quality Control

278 08/12/17

41

220

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

278 08/12/17

40

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Stop



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Start Date: 10/12/2009 Start Qty: 1.00



Customer Item ID:

Required Date: 23/12/2009 Required Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

M112588

0.00 pressure-wash => M109-12-18 (X1)

0.00

Memo

START TIME: 8:05
OVEN TEMPERATURE: 320°
FINISH TIME: 8:35

BR 09-12-21 Q -

240



QC

Quality Control

QC3- Inspect Part Finish

0.00 => M109-12-21

0.00

Memo

(X1) Q

250



HandFinish

Hand Finishing

HandFinishing

0.00 => M109-12-21

0.00

Memo

- 1-Inspect for foreign objects as per QSI 02
- 2-Install Inserts, Weaplate and Cap per Dwg D2966. Insert a drop of sikaflex at insert holes before installing wearplates. Seal Aft Cap using Sikaflex. Install bushing and nut. By looking Fwd, install nut t

3-Wing Walk Batch: M112623

Sikaflex : M112391 2010/01

M109/12/21

(X1) Q

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Start Date: 10/12/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 23/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>MA</u>	<u>08</u>	<u>12</u>	<u>29</u> (1)
270 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo *****ENSURE INSERT ARE AT LOCATION (6) AS PER DWG D2966*****	0.00 0.00				<u>MA</u>	<u>09</u>	<u>12</u>	<u>29</u> (1)
280 Packaging Packaging	Pick Kit Memo	0.00 0.00				<u>9/12/09</u>	<u>SL</u>	<u>(10)</u>	

B54515

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Start Date: 10/12/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 23/12/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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290

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

⇒ 8101015



Quality Control

300

Packaging

0.00



Packaging

Memo

0.00

REVA

10-1-5



Packaging

Identify and pack for shipping as per PPP D105-674-011G
Location: 82

310

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/01/06

Quality Control

CMF

10-01-05

Picklist Print

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Page 1

Work Order ID: 54515

Parent Item: D105-674-011G

Parent Item Name: Skidtube, Grey

Start Date: 10/12/2009

Required Date: 23/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2962-125

Manufactured

No

110

Each

35.0000

1.0000



Outer Tube Extrusion

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

35

17532

35

140

Each

32.0000

1.0000

D2964

Manufactured

No



Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

32

14101

32

200

Each

0.0000

1.0000

D2976

Manufactured

No



BO 105 Skidtube I Beam

D2971

Manufactured

No



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

39

44445

39

DP 9-12-14

1 BE 09/12/15

B 521062

1 119/12/16

1 BE 09/12/17

Picklist Print

Page 2

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Work Order ID: 54515

Parent Item: D105-674-011G

Parent Item Name: Skidtube, Grey

Start Date: 10/12/2009

Required Date: 23/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2973		Manufactured	No			200	Each	213.0000	7.0000			



Cross Bolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

213

14636

213

D2965

Manufactured No

250

Each

59.0000

1.0000



Cap, 105 Skidtube

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP4

58

50924

2

52057

56

Main Warehouse

ST

1

43288

1

7 BE 09/12/17

B541738

XL JM 09-12-21

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Shop Packet Print

Page 2

Picklist Print

Page 3

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Work Order ID: 54515



Parent Item: D105-674-011G



Parent Item Name: Skidtube, Grey

Start Date: 10/12/2009

Required Date: 23/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Inst. Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
----------------------------	------------------------	---------------	-------------	---------------------	-------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2970-1		Manufactured	No			250	Each	25.0000	1.0000			
Wearplate												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	25	
43726	9	
48213	16	

X1 M 09-12-21

D2970-3		Manufactured	No			250	Each	22.0000	1.0000			
Wearplate												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	22	
43727	6	
48214	16	

X1 M 09-12-21

D3176-1		Manufactured	No			250	Each	15.0000	1.0000			
Bushing												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	15	
37586	15	

X1 M 09-12-21

Picklist Print

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Work Order ID: 54515

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Parent Item Name: Skidtube, Grey

Start Date: 10/12/2009


Required Date: 23/12/2009

Comments:

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3176-3		Manufactured	No			250	Each	25.0000	1.0000			
												
Nut												

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	25	
	37585	5	
	44896	20	

X1 09-12-21

ALS7-1032-130		Purchased	No			250	Each	2,330.000	36.0000			
												
Insert												

Warehouse	Location	Loc Qty	Loc Code
Main Warehouse	ST	2330	
	105855	16	
	108606	52	
	11529	938	
	111779	313	
	112772	11	
	113238	1000	

X1 09-12-21

Picklist Print

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Start Date: 10/12/2009

Required Date: 23/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-08		Purchased	No			250	Each	2,860.000	26.0000			
Screw												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	2860	
110467	164	
110552	696	
110835	2000	

X 26 09-12-21

AN960JD10L

Purchased

No

250

Each

5,433.000

28.0000

Washer

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	5433	
101291	16	
104885	153	
105793	236	
109632	274	
110985	4754	

X 26 09-12-21

Picklist Print

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Parent Item Name: Skidtube, Grey


Comments:

Start Date: 10/12/2009

Required Date: 23/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit# Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-09		Purchased	No			250	Each	765.0000	2.0000			
												
Screw												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	765	
107378	23	
111650	500	
8057	209	
8912	33	

X2 09-12-21

D2972



Bushing

Manufactured No

290 Each 123.0000 6.0000

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	123	
33544	92	
44160	31	

6

D2974



Packer

Manufactured No

290 Each 11.0000 1.0000

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	11	
42715	11	

9/12/09 SP

Picklist Print

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Comments:

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	-------------	--------------------------	---------------	----------------	--------

D2975

Manufactured

No

290

Each

17.0000

2.0000



Wearshoe

9/12/29 SL

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

17

41443

6

44894

11

2

AN4-51A

Purchased

No

290

Each

362.0000

3.0000



Bolt

9/12/29 SL

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

362

111635

7

112489

5

112720

50

113121

100

113226

200

3

Picklist Print

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---------------------------------	------------------------	---------------	---------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960JD10L

Purchased

No

290

Each

5,433.000

8.0000



Washer

9/12/29 sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5433

101291

16

104885

153

105793

236

109632

274

110985

4754

8

MS21042L4

Purchased

No

290

Each

3,927.000

3.0000



Nut

9/12/29 sf 10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3927

110507

184

111827

3743

15924

0

3

Picklist Print

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS27039-1-08

Purchased

No

290

Each

2,860.000

8.0000



Screw



9/12/29

SD

Ⓢ

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2860

110467

164

110552

696

110835

2000

8



DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2966	REV. A SHEET 1 OF 2
DATE 00.03.08		TITLE BO 105 SKIDTUBE ASSEMBLY	SCALE NTS
A	00.03.08	NEW ISSUE	

RELEASED
00.05.11 #

Qty	Part Number	Description
X	D2966-041	SKIDTUBE ASSEMBLY
1	D2962-125	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2970-1	WEARPLATE
1	D2970-3	WEARPLATE
1	D2971	CROSS BOLT SPACER
7	D2973	CROSS BOLT SPACER
1	D2976	WEB
36	ALS7-1032-130 or ALS4-1032-130 or AKS7-1032-130 or AKS4-1032-130	INSERT
28	AN960JD10L	WASHER
26	MS27039-1-08	SCREW
2	MS27039-1-09	SCREW
1	D3176-1	BUSHING
1	D3176-3	NUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54515
B809-12-10

A2

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) WELDING TO BE DONE PER DART QSI 004.
- 3) INSERT D2976 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 4) USE DART DRILL TEMPLATE DT8451 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION B-B (34 PLACES) AFTER FINISH. SEAL WEARPLATE SCREWS WITH SIKAFLEX-241/-291.
- 5) DO NOT INSTALL MS27039-1-08 SCREWS AND AN960JD10L WASHERS IN THESE LOCATIONS.
- 6) INSTALL ALS7-1032-130 INSERT, MS27039-1-08 SCREW, AND AN960JD10L WASHER IN 2 PLACES THIS LOCATION BEFORE POWDER COATING.
- 7) FINISH:
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2976 WEB
POWDER COAT ASSEMBLY ~~GLOSS WHITE (REF 4.3.6.1)~~ PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4 (OPTIONAL) BLACK SANDTEX (REF 4.3.5.7)

A1

01.01.29
CP 01.01.30

A2	02.10.30	ADD D3176-1/-3	[Signature]
A1	01.01.29	CHANGE COLOR TO BLACK SANDTEX	[Signature]

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NO. 192

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Bardley Elliot
Job number: 44849
Part number: D105 674 011 WC
Description: 60 105
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass ☒ fail ☐
pass ☒ fail ☐

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐
pass ☒ fail ☐

Qualifier Pct Duvel Date of Test Coupon 09-02-05

Welder Bardley Elliot Date of Test Coupon 09-02-05

The above named individual is qualified in accordance with AWS D17.1.2001 to weld